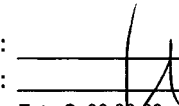
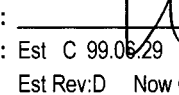


Date: Tuesday, 18/12/2007 7:51:45 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L/L 1/L3 SCUFF PLATE, FWD RH
Job Number	: 36394		
Estimate Number	: 12269		
P.O. Number	:	Part Number	: D206555006
This Issue	: 18/12/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D206-555 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 31605	Drawing Revision	: C
	Type : SMALL / MED FAB	Material	:
Written By	: 	Due Date	: 15/01/2008
Checked & Approved By	: 	Qty:	10
Comment	: Est C 99.06.29 Returned to Electro Polish DM Est Rev:D Now On Waterjet 07-01-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-006

2.0

M304S25GA

260-A

304/316 .020" Sheet



Comment: Qty.: 0.4610 sf(s)/Unit Total: 4.6100 sf(s)

304/316 .020" Sheet

Batch: 105591

HB 07-12-18

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D206-555

Dwg Rev: C

HB 07-12-18

Prog Rev: C

2-Deburr if necessary

HB 07-12-18

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK





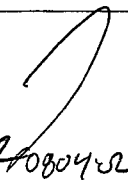

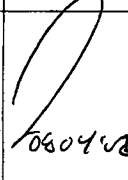
Comment: SECOND CHECK

5 7/12/10 (11) (11) (11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-535-006 PAR #: N/A Fault Category: Engineering NCR: Yes No DQA: LD Date: 28/04/02
 QA: N/C Closed: _____ Date: _____

NCR: <u>36394</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-04-02	S.O	Parts discontinued, and to be Quarantined as per NCR 241		Parts to go to Engineering for investigation per NCR 241	 08/04/02			

NOTE: Date & initial all entries

Date: Tuesday, 18/12/2007 7:51:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD RH

Job Number: 36394

Part Number: D206555006

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8318-6

Finish form on bench forming Jig DT 8319-6

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: _____

Possible supplier: TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/12/2007 7:51:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD RH

Job Number: 36394

Part Number: D206555006

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-02

h

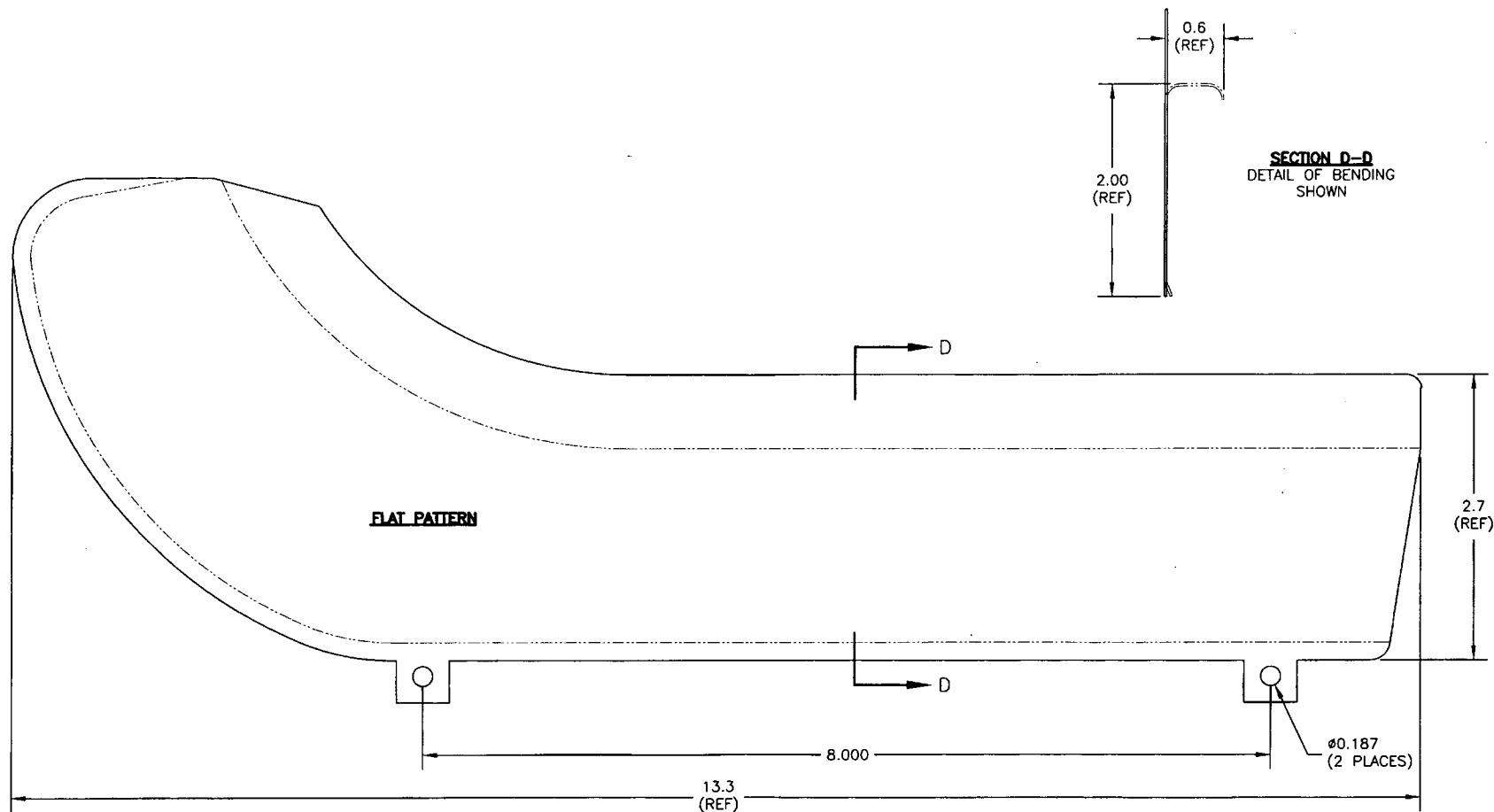
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

Handwritten: 36394

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	REV. C SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

